

Work Order ID 149053

Tuesday, July 19, 2016 10:17:49 AM

149053

PRELIMINARY ISSUE

Page 1

Item ID: D206-642-522PHI

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Stop

NS2

Start Date: 7/19/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

DAS

21

9-89

Approvals:

Process Plan:

Date: JUL 19 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	Q		DAS 6 9-89	JUL 26 2016			21 9-89	16 07 27	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-642-512								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

522 PHI

DAS
21
9-89

DAS
27
AUG 04 2016

QC

DAS
28
9-89 JUL 27 2016

DAS
27
9-89 AUG 04 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 149053

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149053

Page 2

Item ID: D206-642-522PHI
 Revision ID: PRELIM
 Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 7/19/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-512 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

AUG 13 2016

POSITIVE RECALL

EFFECTIVE 11/20/22 AUTH LC

RELEASED DAS DATE 11/20/23

Rev Q 9-89

ECN 16-620

SA 8/13/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
		OTHER : ☐									

Picklist Print

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Page 1

Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.23 NEW ISSUE LL VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5C15A *AN5C15A* Bolt		Purchased	No				Each	23.0000		1			PC DAS 28 9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
over003	20	
M135058	20	
ST337	3	
M130466	3	

AN5C34A *AN5C34A* Bolt		Purchased	No				Each	104.0000		2			PC DAS 28 9-89
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DAS
27
9-89

Location	Loc Qty	Loc Code
FG	2	
18918	2	
over004	88	
m131855	8	
m131856	8	
m132169	8	
m132381	8	
m132522	8	
m132674	8	
m133332	8	
m133917	8	
m133920	8	
m133921	8	
m134131	8	
ST336	14	
m130033	14	

JUL 27 2016

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D206-648-013PHI Manufactured No

Each 0.0000

Start Qty: 1.00

Required Qty: 1.00

D206-648-013PHI

Ground Handling Wheel Modification

D3672-7 Manufactured No

Each 803.0000

D3672-7

Washer, Phenolic

Location

Loc Qty

Loc Code

FG 40

129987 25

133986 15

ST049 263

142572 263

ST051A 500

147220 500

NAS1149C0532R Purchased No

Each 352.0000

NAS1149C0532R

WASHER

Location

Loc Qty

Loc Code

GA 60

116513 60

ST260a 200

m135056 200

ST266 92

m134756 92

D2932-2PHI Manufactured No

Each 0.0000

D2932-2PHI

Saddle RH Out, 206

D2933-2PHI Manufactured No

Each 0.0000

D2933-2PHI

Saddle RH In, 206

27

9-89

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Shop Packet Print

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DAS
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DAS
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1 147486 SL DAS 28 9-89

24 PC DAS 28 9-89

8 PC DAS 28 9-89

JUL 27 2016

1 X B147238 PC DAS 28 9-89

1 X B147358 PC DAS 28 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2938-2PHI

Manufactured No

Each 0.0000

Start Qty: 1.00

Required Qty: 1.00

D2938-2PHI

Saddle RH Out, 206

D2939-2PHI

Manufactured No

Each 0.0000

**

① XB 147 339 PC DAS 28 9-89

D2939-2PHI

Saddle RH In, 206

AN3C41A

Purchased No

Each 302.0000

**

① B 147 244 PC DAS 28 9-89

AN3C41A

Bolt

**

8 PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG 10
122843 5
124975 1
m130081 4
OVER002 225
m132169 75
m132381 75
m132522 75
ST347 67
131651 67

DAS
27
9-89

D2652

Manufactured No

Each 477.0000

**

D2652

Bushing

16 PC DAS 28 9-89

Location

Loc Qty

Loc Code

FG 45
31985 45
ST009 124
147559 124
ST012a 308
145959 308

DAS
27
9-89

JUL 27 2016

16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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		OTHER : ☐																							

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Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH,High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

MS21043-3

Purchased

No

Each

Start Qty: 1.00
976.0000

Required Qty: 1.00

MS21043-3

Nut

**

Pe
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	237	
m133990	237	
OVER007	400	
m135058	400	20
ST302	142	
m134861	142	
ST304	106	
m131340	106	

AN5C11A

Purchased

No

Each

116.0000

AN5C11A

Bolt

**

PC
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	4	
103715	4	
over003	40	
M135058	40	
ST338	72	
M131305	22	
M131624	50	4

JUL 27 2016

DQA: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval ☐																	
Description Work Order Deviation		Disposition		Completed By _____																	
				Lead hand / Supervisor Approval Verification ☐																	
				QC / QA Coordinator Approval ☐																	
<table style="width:100%; border: none;"> <tr> <td style="width:25%; text-align: center; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:25%; text-align: center; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%; text-align: center; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%; text-align: center; vertical-align: top;"> FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:25%; text-align: center; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:25%; text-align: center; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>					Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐											
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OTHER : ☐																					

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN4C6A

Purchased

No

Each

345.0000

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Bolt

**

12
9X M134955 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	14	
103344	4	
121657	10	
ST345	331	
m134502	6	
<u>m134861</u>	75	
m134955	150	
m135127	100	

3

24

D3672-3

Manufactured

No

Each

717.0000

**

D3672-3

Washer, Phenolic

pe DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	100	
133083	52	
134449	48	
FP001	213	
132639	213	
ST049	404	
142571	13	
<u>146277</u>	391	

24

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																														
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																										
Description Work Order Deviation				Disposition																																																														
Root Cause		FAULT CATEGORY																																																																
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :				
Misidentified ☐	Past Due ☐																																																																	

Picklist Print

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Page 6

Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

NAS1149C0432R

Purchased

No

Each

977.0000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

WASHER

**

24
X M135297
DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

801

m125807

427

m134676

374

ST266

176

m134676

176

Each

753.0000

**

12
PC DAS 28 9-89

MS21043-4

Purchased

No

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

300

m134754

300

ST302

396

m134502

96

m134943

300

DAS
27
9-89

JUL 27 2016

12

D206-642-522PHI

1k B 149736

DAS
28
9-89

DAS
27

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D3456-1

Manufactured No

Each

87.0000

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Washer

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST037

5

144158

5

ST038A

75

147066

25

147799

50

D3457-1

Manufactured No

Each

108.0000

D3457-1

Washer

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

32409

10

ST037

98

145625

98

D2712

Manufactured No

Each

309.0000

D2712

Set Screw

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

154

140532

44

141690

100

89929

10

ST012a

100

147570

50

147801

50

JUL 27 2016

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

D2934
D2934
Saddle Spacer

Manufactured No

Each

58.0000

Start Qty: 1.00

Required Qty: 1.00

**

2

JK

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

6

31929

6

ST014

52

141428

12

147488

40

Each

69.0000

**

2

DAS
28
9-89

D2935
D2935
Saddle Spacer

Manufactured No

Location

Loc Qty

Loc Code

FG

6

31793

6

ST014

63

146008

33

147574

30

DAS
27
9-89

2

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN3C36A

Purchased

No

Each

240.0000

Start Qty: 1.00

Required Qty: 1.00

AN3C36A

Bolt

**

9 M135310 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	47	
101261	4	
122204	2	
m131367	1	
m132169	40	
FP001	80	
m131856	1	
m132381	79	
OVER002	80	
m133916	80	
ST347	33	
m132522	33	

AN3C35A

Purchased

No

Each

47.0000

AN3C35A

Bolt

**

3 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	4	
18914	4	
ST347	43	
M132317	18	
M133694	25	

3

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

NAS1149C0332R

Purchased

No

Each

3,118.000

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

1686

m135046

1686

GA

141

m133284

141

ST266

1291

m134736

1291

Each

992.0000

**

24

PC

DAS
28
9-89

D3672-1

Manufactured

No

D3672-1

Washer, Phenolic

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

482

112218

8

134785

474

ST049

500

147077

500

Each

35.0000

**

2

PC

DAS
28
9-89

D3396-3

Manufactured

No

D3396-3

Bushings

DAS
27
9-89

Location

Loc Qty

Loc Code

ST034

35

132598

12

147439

23

JUL 27 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 149053

149053

Parent Item: D206-642-522PHI

D206-642-522PHI

Parent Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float
Compatible

Start Date: 7/19/2016

Required Date: 7/27/2016

AN5C35A

Purchased

No

Each

61.0000

Start Qty: 1.00

Required Qty: 1.00

AN5C35A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

ST336

61

M129871

61

Each

123.0000

**

DAS
28
9-89

AN5C32A

Purchased

No

AN5C32A

BOLT

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

18918

4

over004

100

131650

100

ST336

19

m132102

19

Each

162.0000

**

DAS
28
9-89

MS21043-5

Purchased

No

MS21043-5

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

76

116548

76

ST302

66

m135157

66

JUL 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation.				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : ☐			

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
			X	D206-642-561	FLOAT SKIDTUBE
10	8	8		AN3C41A	BOLT
11	16	16		D2652	BUSHING
12A	8	8		MS21043-3	NUT
12B	16	16		D3672-7	WASHER
13	4	4		AN5C11A (or. AN5C12A)	* BOLT (2)
14	4	4		AN5C11A (or. AN5C13A)	* BOLT (2)
15A	8	8		NAS1149C0532R	WASHER
15B	8	8		D3672-7	WASHER
16	12	12		AN4C6A	BOLT
17A	24	24		D3672-3	WASHER
17B	24	24		NAS1149C0432R	WASHER
18	12	12		MS21043-4	NUT
37	10	10		D2712	SET SCREW
38	2	2		D2934	SADDLE SPACER
39	2	2		D2935	SADDLE SPACER
50	9	9		AN3C36A	BOLT
51	3	3		AN3C35A	BOLT
52	24	24		NAS1149C0332R	WASHER
53	24	24		D3672-1	WASHER
54	12	12		MS21043-3	NUT
55	2	2		D3396-3	SPACER
56A	1	1		AN5C35A	BOLT
56B	1	1		AN5C15A	BOLT
60	2	2		AN5C32A	BOLT
61	2	2		AN5C34A	BOLT
62	4	4		MS21043-5	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-045 ASSEMBLY ABOVE

(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9749	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ADD -521/-522/-561 SKIDTUBES NTS	
DATE	16.05.30	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. Q AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D206-642 REV. 6 OR LATER APPROVED REVISION

REF. FAA STC: SA00475SE

REF. TCCA STC: SH98-4

REF. EASA STC: EASA.IM.R.S.01320

PURPOSE:

TO ADD D206-642-521/-522 SKIDTUBE INSTALLATIONS WITH WEARPADS ONLY AS
PREFERRED BY SOME CUSTOMERS.

PARTS LIST:

PARTS LIST OF SECTION 4.7 OF IIN-D206-642 REV. Q AND SECTION 32.17 OF ICA-D206-642
REV. 6 IS AMENDED AS SHOWN BELOW TO REFLECT THE ADDITION OF D206-642-521/-522/-
561 CONFIGURATIONS.

ITEM	Qty -521	Qty -522	Qty -561	Part Number	Description
	X			D206-642-521	FLOAT SKIDTUBE INSTALLATION, LH
		X		D206-642-522	FLOAT SKIDTUBE INSTALLATION, RH
	1	1	X	D206-642-521/-522/-561	FLOAT SKIDTUBE
	1	1	2	D206-648-013	GROUND HANDLING KIT
1			1	D3274-045	SKIDTUBE ASSEMBLY
3			1	D2646	* AFT CAP (1)
4			2	AN3C4A	* BOLT (1)
5A			2	NAS1149C0332R	* WASHER (1)
5B			2	D3672-1	* WASHER (1)
20A			9	D3537-9	* WEARPAD (1)
21A			1	D3537-11	* WEARPAD (1)
26A			40	AN3C4A	* BOLT (1)
26B			40	NAS1149C0332R	* WASHER (1)
26C			40	ALS7-1032-130	* INSERT (1)
34			1	MS27039C4-06	* SCREW (1)
35			1	NAS1149C0463	* WASHER (1)
6	1			D2932-1	SADDLE, FWD OUT, LH
6		1		D2932-2	SADDLE, FWD OUT, RH
7	1			D2933-1	SADDLE, FWD IN, LH
7		1		D2933-2	SADDLE, FWD IN, RH
8	1			D2938-1	SADDLE, AFT OUT, LH
8		1		D2938-2	SADDLE, AFT OUT, RH
9	1			D2939-1	SADDLE, AFT IN, LH
9		1		D2939-2	SADDLE, AFT IN, RH

A	NEW ISSUE	AK	16.05.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AK		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9749	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ADD -521/-522/-561 SKIDTUBES NTS	
DATE	16.05.30	COPYRIGHT © 2016 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Work Order ID 149053

149053

PRELIMINARY ISSUE

Page 1

Tuesday, July 19, 2016 10:17:49 AM

Item ID: D206-642-522PHI

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Skidtube RH, High Gear, Standard Wearplates, DART (Apical) Tri-Bag Float Compatible

Start Date: 7/19/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/27/2016 Req'd Qty: 1.00

1

Customer:

Reference:

DAS

21

Run Start *NR1*

Approvals:

Process Plan:

9-89

Date: JUL 19 2016

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DAS

JUL 26 2016

DAS

21

JUL 27 2016

IIN-D206-642

Q

6

9-89

100

Document Control

9-89 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-642-512 CHG006

DAS

21

9-89

CHG 001

see attachment

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

Change Record

PAGE 1 OF 1

Part Number: D206-642-521PHI/-522PHI

Description: FLOAT SKIDTUBE , LH/RH

[illegible]